# Work Order ID 55775

February 1, 2010 10:21:42 AM



Page 1

Item ID:

D206-642-441

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Replacement Skidtube

**Start Date:** Required Date: 2/19/10

2/02/10

Start Qty: 1.00

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

**Process Plan:** 

Date://>20/

Tooling:

Date:

Run

Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ **Work Center ID**  Operation **Description**  Set Up/ **Run Hours** 

Draw Number

Draw Rev.

Plan Accept Qty Code

Reject Qty

Reject Number

Stamp

**Draw Nbr** 

**Revision Nbr** 

D2650

Rev F

100

DOCUMENT CONTROL

Memo

0.00

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-441

CHG002

W/O:			W	ORK ORDER CHA	NGES				· r
DATE	STEP	PR	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
<u> </u>				· · · · · · · · · · · · · · · · · · ·					
Part No	•	PAR #:	Fault Cat	egory:	NCR: Ye	s No <b>DQ</b>	A:	_ Date: _	
	Reso	olution:					•	Date: _	
NCR:			WORK ORI	DER NON-CONFOR	RMANCE (NO	R)			
DATE	STEP	Description of NC	Initial	Corrective Action	Section B	. 0 1	cation	Approval	Approval
		Section A	Chief Eng	Action Descript Chief Eng	Dat		ion C	Chief Eng	QC Inspector
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### Work Order ID 55775

February 1, 2010 10:21:42 AM

Required Date: 2/19/10

Item ID: **Revision ID:**  D206-642-441

Accept



Setup Start



Stop

**Item Name: Start Date:** 

2/02/10

Start Oty: 1.00

**Req'd Qty:** 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

Process Plan: Approvals:

Replacement Skidtube

Date:

Tooling:

Date:

Plan

Code

Start



Date:

SPC (Y/N):

Draw

Number

Date:

Draw

Rev.

Accept

**Qty** 

Run

Reject

**Qty** 

Reject Insp. Number Stamp

Sequence ID/ **Work Center ID** 

110

Skidtubes

Skidtubes

Operation Description

QC: \_\_\_\_

Set Up/ **Run Hours** 

0.00

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as

A/R - Aluminum Rod MIL250

4-Grind weld flush to cap on top surface only.

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

Marcon   Step										•		
Part No:PAR #: Fault Category: NCR: Yes No DQA: Date:	, ,					ES	RK ORDER CHANG	W			W/O:	
Resolution:	Approval QC Inspector	Approval Chief Eng / Prod Mgr	Qty	Date	Ву		PROCEDURE CHANGE			STEP	DATE	
Resolution:											ì	
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Section A Initial Action Description Sign & Section C Chief Eng	Approval	Approval	ation	Verific	<u> </u>	ion B		<u> </u>		STEP	DATE	
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Page 3

February 1, 2010 10:21:42 AM

Item ID:

D206-642-441

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Replacement Skidtube

**Start Date:** Required Date: 2/19/10

2/02/10

Start Qty: 1.00

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

QC:

Date: \_\_\_\_\_

Date:

Tooling:

SPC (Y/N):

Date: \_\_\_\_\_\_

Rev.

Date:

Run Start

Stop

Sequence ID/

**Work Center ID** 

115

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Memo

Memo

Set Up/ **Run Hours** 

0.00

0.00 8 rolulos

Draw Number

Plan Draw

Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

116

QC

**Quality Control** 

OC10- Inspect visual per QSI004- ground welds

2) 5 10/0/03

120

HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

BE 10/02/03

Hand Finishing

W/O:			WO	RK ORDER CHANC	GES.					τ '
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### Work Order ID 55775



Page 4

February 1, 2010 10:21:42 AM

Item ID:

D206-642-441

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Replacement Skidtube

**Start Date:** 

Required Date: 2/19/10

2/02/10

QC:

Start Qty: 1.00

Req'd Qty: 1.00

Operation

Description



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

130

Memo

QC3- Inspect Part Finish

Set Up/ **Run Hours** 

0.00

0.00

Draw Number Draw Rev.

Plan Code Accept Qty

Reject Qty

Reject Insp. Number Stamp

**Quality Control** 

Dart Aeros	space Lte	d
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W/O:			WO	RK ORDER CHAN	GES					,
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Part No	•	PAR #:	Fault Categ	jory:	NCF	R: Yes	No DQ	<b>4</b> :	_ Date: _	
	Res	olution:	Disposition	]:	QA:	N/C CI	sed:	·-·	Date: _	
NCR:			WORK ORDE	R NON-CONFORM	IANCE	(NCR	)			
DATE	STEP	EP Description of NC			ction B		Verific	cation	Approval	Approval
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Page 5

Item ID:

D206-642-441

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Replacement Skidtube

**Start Date:** 

Required Date: 2/19/10

2/02/10

QC:

Start Qty: 1.00

Reg'd Oty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling: Date:

Date:

Date:

Run

Start

Stop



Sequence ID/ **Work Center ID** 

140

Skidtubes

Skidtubes

**Operation** Description Set Up/ **Run Hours** 

SPC (Y/N):

Draw Number Draw Rev.

Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

Skidtubes

Memo

0.00

0.00

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting

Dart Aerospace Lt	d
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W/O:			WO	RK ORDER CHANG	GES				• ,
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Categ	jory:	NCR: Yes	No <b>DQ</b>	A:	Date: _	
	Reso	olution:	Disposition	:	QA: N/C (	Closed:		Date: _	
NCR:		•	WORK ORDE	R NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC	Corrective Action		tion B	Verifi	cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
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# Work Order ID 55775



Page 6

February 1, 2010 10:21:42 AM Item ID:

D206-642-441

Accept



Setup Start



**Revision ID:** 

Replacement Skidtube Item Name:

**Start Date:** 2/02/10 Required Date: 2/19/10

Start Qty: 1.00

Reg'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Draw

Number

Reference:

Process Plan: \_\_\_\_\_ Date:

Date:

**Tooling:** 

0.00

0.00

Date:

Run

Reject

Qty

Start

Stop



Approvals:

QC:

SPC (Y/N):

Date:

Draw

Rev.

Plan

Code

Accept

Qty

Stop

Number Stamp

Insp.

Sequence ID/ **Work Center ID** 

150

QC

Quality Control

Operation **Description** 

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours** 

Reject

160

Skidtubes Skidtubes Skidtubes

Memo

Memo

0.00

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod [ M/1250 7

2-Grind welds flush as per Dwg D2650.

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Deburr

DE 1402/08

10-2-8

Dart Aerospace Li	_td
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W/O:			V	ORK ORDER CHAN	IGES					, r
DATE	STEP	PRO	OCEDURE CH	IANGE	I	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Ca	tegory:	NCR:	Yes N	lo <b>DQA</b>	:	Date:	
	R	esolution:	Disposit	ion:	QA: N	I/C Clo	sed:		Date: _	
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DATE	STEP	Description of NC		ection B		Verifica	ation	Approval	Approval	
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February 1, 2010 10:21:42 AM

Item ID:

D206-642-441

Accept



Setup Start



**Revision ID:** 

Item Name:

Replacement Skidtube

**Start Date:** 

Required Date: 2/19/10

2/02/10

Start Qty: 1.00

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date: Tooling: Date: Date:\_\_\_\_\_ Run

Start Stop

Stop

Date: SPC (Y/N):

Draw Number Draw Rev.

Plan Accept Code Qty

Reject Qty

Reject Insp. Number Stamp

170

Sequence ID/

**Work Center ID** 

Skidtubes

HandFinishing

Operation

Description

QC:

Memo

Memo

Memo

0.00

Install D2680-041 Nut Plate as per Dwg D2650 Skidtubes

0.00

Set Up/

**Run Hours** 

10-2-16

180

Quality Control

QC10- Inspect visual per QS1004- ground welds

190

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

W/O:			W	ORK ORDER CHANG	ES	* 20012			,
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date:	
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DATE	STEP	Description of NC		ion B	Verifi	ication	Approval	Approval	
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February 1, 2010 10:21:42 AM

Item ID:

D206-642-441

Accept



Setup Start

Stop



**Revision ID:** 

Item Name: Replacement Skidtube

**Start Date:** 2/02/10

Start Qty: 1.00 Req'd Qty: 1.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan: Date:

Pressure Wash per QSI005 4.3

Tooling:

Date:

Start



QC:

Required Date: 2/19/10

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID** 

Operation Description Set Up/ **Run Hours**  Draw Number Draw Plan Rev. Code

Accept Qty

Reject

Insp.

200

HandFinish

Qty

Run

Reject Number Stamp

Hand Finishing

205 Powdercoat Powder Coating

OVEN TEMPER FINISH TIME:

220

spect Part Finish

0.00

0.00

T 10.02-24

Quality Control

Memo

Memo START TIME:

	•							
W/O:			WO	RK ORDER CHANG	GES			,
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date Qt	y Approval Chief Eng / Prod Mgr	Approval QC Inspector
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						-		
Part No	•	PAR #:	Fault Categ	jory:	NCR: Yes	No DQA: _	Date: _	
	Res	olution:	Disposition	:	_ QA: N/C Cld	osed:	Date: _	
NCR:		,	WORK ORDE	R NON-CONFORM	ANCE (NCR	)		100
DATE	STEP	Description of NC			tion B	Verificatio	n Approval	Approval
DAIL	JILF	Section A	Initial Chief Eng	Action Description  Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Page 9

Item ID:

D206-642-441

Accept



Setup Start

**Revision ID:** 

Item Name:

Replacement Skidtube

2/02/10 **Start Date:** Required Date: 2/19/10

Start Qty: 1.00

Req'd Qty: 1.00

**Cust Item ID:** 

**Customer:** 

Reference:

A	nn.	rov	/al	S:

QC:

Process Plan:

Date:

Date: Tooling:

0.00

SPC (Y/N):

Date:

Stop

Start

Stop



Sequence ID/ **Work Center ID** 

230

HandFinish

Hand Finishing

Operation **Description** 

HandFinishing

Set Up/ Run Hours Draw

Rev. Number

Date:

Draw Plan Code

Accept **Qty** 

Reject **Qty** 

Run

Reject Insp. Number Stamp

Memo

0.00

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/RUSikaflex-2910/10/50/sikaflex expiry date:0\_2010/0

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive A/R□□Sikaflex-291□

Sikaflex expiry date:L. 102/01

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4L Batch: MIII 3642

Bl 10-3-1

W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No:		PAR #:	Fault Cate	egory:	NCR: Yes No DQA: Date:						
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NCR:			WORK ORE	ER NON-CONFORM	ANCE (NO	R)					
DATE	STEP	Description of NC	Corrective Action Section B			Verif	ication	Approval	Approval		
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#### Work Order ID 55775

February 1, 2010 10:21:42 AM



Page 10

Item ID:

D206-642-441

Accept

Setup Start

Stop

Start



**Revision ID:** 

Item Name:

Replacement Skidtube

**Start Date:** Required Date: 2/19/10

2/02/10

Start Oty: 1.00

Req'd Qty: 1.00

**Cust Item ID:** 

**Customer:** 

Draw

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Draw

Stop

Sequence ID/

**Work Center ID** 

240 

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours** 

Number Rev.

Date:

Plan Code

Accept Qty Qty

Run

Reject

Reject Number Stamp

Insp.

250

Packaging

Packaging

260

QC

Quality Control

Memo

0.00

0.00

Packaging

Memo

Identify and pack for shipping as per PPP D206-642-441

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

	-											
W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHAI	NGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No:		PAR #:	Fault Cate	jory:	NCR: Yes No DQA: Date:							
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NCR:		·	WORK ORDE	ER NON-CONFORM	ANCE (I	VCR)						
DATE	STEP	Description of NC	Corrective Action Section B			Verifica			Approval	Approval		
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Picklist	Prin	t
February 1,	2010	I

10:21:47 AM

Work Order ID: 55775

D206-642-441

Parent Item Name: Replacement Skidtube

**Comments:** 

Parent Item:

IPP Rev:H□05.10.11□Added D3429-1 per CHG002 □KJ/CP/JLM IPP Rev:I 08-05-01 add QC3 DD verified by:EC

IPP Rev:J 08-09-29

revF as per dwg DD verified by:

**Start Date: 2/02/10** 

Start Qty: 1.00

Required Date: 2/19/10

Required Qty: 1.00

Component Item ID/

Replacement Mfg/ D2620

Manufactured

Manufactured

Bin Primary No

No

Last

Route 110

110

Unit of Each

Qty on 17.0000

Remaining 1.0000

Qty

Date

Loc Oty

Loc Code

1 BE10/02/02

Status

Page 1

Skidtube, 206 Skidtube

Warehouse Location

Main Warehouse

ST 54448

55559

17 7 10

Each

58.0000

1.0000

D2646

Aft Cap

<u>Warehouse</u>	Loc Oty	Loc Code	
<b>Location</b>			
Main Warehouse			
FP6	29		1 ch 10-03-1.
52663	29		10000000
Main Warehouse			•
fp7	13		
52663	13		
Main Warehouse			
ST	16		
46327	4		
48109	12		

Dart Aerosp	ace Ltd
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W/O:			WORK ORDER CHANGES									
DATE	STEP	PR	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
					NCR: Yes No DQA: Date:							
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NCR:			WORK ORDE	ER NON-CONFORM	ANCE	(NCR						
DATE	STEP	Description of NC				Verific			ation Approval			
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February 1, 2010 10:21:47 AM

Work Order ID: 55775

D206-642-441

Parent Item Name:

**Comments:** 

Parent Item:

Replacement Skidtube

IPP Rev:H□05.10.11 □ Added D3429-1 per CHG002 □KJ/CP/JLM IPP Rev:I 08-05-01 add QC3 DD

verified by:EC IPP Rev:J 08-09-29 revF as per dwg DD verified by:

Replacement Mfg/

Manufactured

Manufactured

Purchased

Bin **Primary** No

Last

Route 140

Unit of Each

Qty on 93.0000

Loc Code

Remaining

1.0000

Start Date: 2/02/10

Start Qty: 1.00

Qty

Date

Required Date: 2/19/10

Required Qty: 1.00

Status

D2647

Cap

Component Item ID/

Warehouse Main Warehouse

No

No

55352

Location

ST

160

93 Each

93

2.0000

1.0000

B 5 10/02/02

Web

D2654-7

Warehouse Location

Main Warehouse

FG

52801

170

2 2

Each

41

20

Loc Oty

Loc Qty

41.0000

Loc Code

Loc Code

2.0000

Cherry Rivet

CCR264SS3-3

Warehouse Loc Qty Location Main Warehouse ST 111548 111827 112314 113539

**Shop Packet Print** 



W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No:		PAR #:	Fault Cate	jory:	_ NCR: Yes	No <b>DQ</b>	A:	Date:	Date:			
	Resolution:		Disposition	):	QA: N/C	Closed:		Date: _				
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)						
DATE	0750	Description of NC Section A		tion B	Vorifi	ication Approv	Annvoyal	Annessal				
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sect	tion C	Approval Chief Eng	Approval QC Inspector			
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#### **Picklist Print**

February 1, 2010 10:21:47 AM

Page 3

Work Order ID: 55775

Parent Item:

Comments:

D206-642-441

Parent Item Name:

Replacement Skidtube

IPP Rev:H□05.10.11□Added D3429-1 per CHG002 □KJ/CP/JLM IPP Rev:I 08-05-01 add QC3 DD verified by:EC

IPP Rev:J 08-09-29 revF as per dwg DD verified by:

No

Manufactured

**Start Date: 2/02/10** 

Required Date: 2/19/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D2649

Replacement Mfg/

Bin No Manufactured

Primary

Last

Route 170

Unit of Each

Qty on Remaining 337.0000 23.0000

Qty

Date

Status

_	D 1	0	
Cross	ROIL	Spac	er

<u>Warehouse</u>	<u>Lo</u>	c Qty	Loc Code				
<b>Location</b>							
Main Warehouse							
LG		310					,
51529		3					10/08
55000		307			_23	BE	10/02/08
Main Warehouse							, ,
ST		27					
36013		5					
47112		18					
48271		4					
	170	Each	57.0000	1.0000			



Nut Plate

Warehouse	Loc Qty	Loc Code
<b>Location</b>		
Main Warehouse		1 10-7-8
ST021	57	
33061	1	
55366	56(/	) ——

V/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	PROCEDURE CHANGE By			Dat	e Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
					,						
Part No		PAR #:	Fault Cate	gory:	NCR: Ye	NCR: Yes No DQA: Date:					
				oosition: QA: N/C Closed: _							
NCR:			WORK ORDE	ER NON-CONFORM	MANCE (NO	R)					
DATE	STEP	Description of NC			ection B	Ve	erification	Approval	Approval		
		Section A	Chief Eng	Action Description Chief Eng	Sigr Dat		Section C	Chief Eng	QC Inspector		
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#### **Picklist Print**

February 1, 2010 10:21:47 AM

Page 4

Work Order ID: 55775

Parent Item:

D206-642-441



Parent Item Name:

Replacement Skidtube

**Comments:** 

IPP Rev:H□05.10.11□Added D3429-1 per CHG002 □KJ/CP/JLM IPP Rev:I 08-05-01 add QC3 DD verified by:EC

Purchased

Purchased

IPP Rev:J 08-09-29

revF as per dwg DD verified by:

**Start Date: 2/02/10** 

Required Date: 2/19/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ ALS4-1032-130

Replacement Mfg/ Purchased Bin Primary No

No

No

Last

Route 230

Each

Unit of

Oty on Remaining 2,253.000 60.0000

Otv

Date

Status

Insert

Warehouse

Loc Oty

230

230

Loc Code

Location

Main Warehouse

ST

110511

2253

2253

Each

3,815.000 62.0000

H 10-03-1

AN960JD10L

Washer

Warehouse Location Loc Qty

Loc Code

Main Warehouse

ST 101291

> 105793 110985~

3815 16

49 3750

Each

0.0000 1.0000

AN960JD416

Washer

NAS149 D 04631

1 BR 10-03-1

W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHA		alo	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date:							
						: N/C Closed: Date:						
NCR:			WORK ORD	ER NON-CONFORM	IANCE	(NCR	)					
DATE	STEP	Description of NC		Corrective Action Section B			Verific	ation	Approval			
DAIL		Section A	Initial Chief Eng	Action Description  Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector		
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February 1, 2010 10:21:48 AM

Work Order ID: 55775

Parent Item:

D206-642-441

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev:H□05.10.11□Added D3429-1 per CHG002 □KJ/CP/JLM IPP Rev:I 08-05-01 add QC3 DD

verified by:EC

IPP Rev:J 08-09-29

revF as per dwg DD verified by:

No

**Start Date: 2/02/10** 

Oty

Required Date: 2/19/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/

Replacement Mfg/

Purchased

Manufactured

Bin Primary No

Last

Route 230

Unit of Each

Remaining Oty on 250.0000 2.0000

Date

Status

CR3212-4-03

Cherry Rivet

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

250 84

166 Each

504.0000 22.0000 

D2651-1

Plug

Loc Code Warehouse Loc Qty Location

230

Main Warehouse

ST

fpa 53349

51530

Main Warehouse 43990

295 295

209 18

191

22 DR 10-3-1.

	•								
W/O:			WC	RK ORDER CHANG	GES				4 4.
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							;		
				-					
Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	s No <b>D</b>	QA:	Date: _	
Resolution:			Disposition	Disposition: QA: N/C Closed:					
NCR:		,	WORK ORD	R NON-CONFORM	ANCE (N	CR)			
DATE	STEP	Description of NC		etion B	Veri	fication	Approval	Approval	
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n&⊹ <sub>Se</sub>	ection C	Chief Eng	QC Inspector

#### **Picklist Print**

Page 6

February 1, 2010 10:21:48 AM

Work Order ID: 55775

Component Item ID/

D206-642-441 Parent Item:

Parent Item Name:

Comments:

Replacement Skidtube

IPP Rev:I 08-05-01 add QC3 DD verified by:EC

Manufactured

Manufactured

IPP Rev:H□05.10.11□Added D3429-1 per CHG002 □KJ/CP/JLM revF as per dwg DD verified by:

Primary

IPP Rev:J 08-09-29 Replacement Mfg/

Manufactured

Bin No Last

Route 230

Unit of Each

Oty on Remaining 693.0000 22.0000

1.0000

**Start Date: 2/02/10** 

Start Qty: 1.00

Date Oty

Status

Required Date: 2/19/10 Required Qty: 1.00

O-Ring

D2651-3

Warehouse Location

Main Warehouse

ST

43849 46114

230

Loc Qty

Loc Code

Each

693 3 690

15.0000

-bl 10-3-1

No

No



Wearshoe

D3535-15

Warehouse Location

Main Warehouse

ST

30750 42233 53462

10 230 Each

Loc Qty

Loc Code

15

10.0000 1.0000 -bl 10-3-1

Wearshoe

D3535-23

Warehouse

Loc Qty

Loc Code

Location Main Warehouse

ST

53467

10 10 1 Bl 10-3-1

Dart Aerospace
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W/O:			WC	RK ORDER CHANG	ES		<del></del>		, 4
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			1,						
Part No		PAR #:							
Resolution:				<u> </u>				Date:	
NCR:				R NON-CONFORMA	ANCE (NC	(R)			
DATE	STEP Description of NC Section A		Initial Action Descri		on B Sign	& Sec	ication tion C	Approval Chief Eng	Approval QC Inspector
				•					

#### **Picklist Print**

February 1, 2010 10:21:48 AM

Work Order ID: 55775

Parent Item:

D206-642-441

Parent Item Name:

Component Item ID/

Replacement Skidtube

Comments:

IPP Rev:H□05.10.11□Added D3429-1 per CHG002 □KJ/CP/JLM

Manufactured

08-05-01 add QC3 DD

verified by:EC revF as per dwg DD verified by:

No

IPP Rev:J 08-09-29

Replacement Mfg/

Bin Manufactured No Primary

Last

Route 230

230

Unit of Each

Qty on 8.0000

Remaining

**Start Date: 2/02/10** 

Start Qty: 1.00

1.0000

Qty

Status

Required Date: 2/19/10

Required Qty: 1.00

Date

Page 7

Wearshoe

D3535-37

Warehouse Location

Loc Code

Main Warehouse

FP

51654

Each

Loc Qty

13.0000

TBL 10-3-1 1.0000

D3536-15

Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

51600

13

13

10-03-1

W/O:		WORK ORDER CHANGES											
DATE	STEP	PR	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
		s.o.											
						1							
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	<b>4</b> :	Date: _	<u> </u>				
Resolution:			Disposition	QA: N/C Closed:			Date:						
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)							
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description			ation	Approval	Approval				
		Section A	Chief Eng	Chief Eng	Date	Secti	on C	Chief Eng	QC Inspector				
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#### **Picklist Print**

Page 8

February 1, 2010 10:21:48 AM

Work Order ID: 55775

D206-642-441

Parent Item Name:

Replacement Skidtube

Comments:

Parent Item:

IPP Rev:H□05.10.11□Added D3429-1 per CHG002 □KJ/CP/JLM

IPP Rev:I 08-05-01 add QC3 DD verified by:EC IPP Rev:J 08-09-29 revF as per dwg DD verified by:

Start Date: 2/02/10

Required Date: 2/19/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D3536-23

Replacement Mfg/

Bin Primary Manufactured

No

Last

Route 230

Unit of Each

Qty on 16.0000

Loc Code

Remaining 1.0000

Qty

Date

Status

Gasket

Warehouse Location Main Warehouse FP 51609 Main Warehouse ST 30754

53468

Manufactured No

10.0000 1.0000

Loc Code

pt-10-3-1

Gasket

D3536-37

Warehouse Loc Qty Location Main Warehouse ST 10 51641 10

- Bil 10-3.1

Dart	<b>Aeros</b>	pace	Ltd
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W/O:			WC	RK ORDER CHANG	GES				£
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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							-		
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	A:	Date: _	
		olution:					ate:		
NCR:		,	WORK ORDI	R NON-CONFORM	ANCE (NCF	R)			•
DATE	STED	Description of NC Corrective Action			Section B Verific			Approval	Approval
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#### **Picklist Print**

Page 9

February 1, 2010 10:21:48 AM

Work Order ID: 55775

D206-642-441

Parent Item Name:

Parent Item:

Replacement Skidtube

Comments:

IPP Rev:H□05.10.11□Added D3429-1 per CHG002 □KJ/CP/JLM

IPP Rev:I 08-05-01 add QC3 DD verified by:EC IPP Rev:J 08-09-29 revF as per dwg DD verified by:

Manufactured

**Start Date: 2/02/10** 

Required Date: 2/19/10

Start Qty: 1.00

Required Qty: 1.00

Date

Component Item ID/ D3537-1

Replacement Mfg/ Manufactured

Bin No

Primary Last

Route 230

Unit of Each

Qty on 118,0000 6,0000

Loc Code

Remaining

Qty

Status

Wearpad

<u>Warehouse</u>
<b>Location</b>
Main Warehouse
ED

48288 Main Warehouse

> FP17 51678

51679 V

116 100

230

Loc Qty

2

16

Each

39.0000 1.0000 6 bl 10-3-1

D3537-3

Wearpad

<u>Warehouse</u>	
<b>Location</b>	
Main Warehouse	
ST	

33881 35697 √ Loc Qty Loc Code 39 33

1 bl 10-3-1.

W/O:			WC	RK ORDER CHANG	ES					•	
DATE	DATE STEP PRO			NGE	By Da			Date Qty Approving Chief Engineer Prod Mg		Approval QC Inspector	
!											
Part No	•	PAR #:	Fault Cate	gory:	NCR:	Yes N	lo <b>DQ</b>	<b>A</b> :	Date:	<u> </u>	
	Res	solution:	Disposition	າ:	QA: N/C Closed:					_ Date:	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (I	VCR)					
DATE	STEP	Description of NC	Initial Action Description			Sign &		ation	Approval	Approval	
		Section A	Chief Eng	Action Description Chief Eng		Date	Secti	on C	Chief Eng	QC Inspector	
		9-1									

February 1, 2010 10:21:48 AM

Work Order ID: 55775

Parent Item:

D206-642-441

Parent Item Name: Replacement Skidtube

Comments:

IPP Rev:H□05.10.11□Added D3429-1 per CHG002 □KJ/CP/JLM IPP Rev:I 08-05-01 add QC3 DD IPP Rev:J 08-09-29

Purchased

Purchased

Bin

No

No

verified by:EC revF as per dwg DD verified by:

**Start Date: 2/02/10** 

Start Qty: 1.00

Required Date: 2/19/10

Required Qty: 1.00

Component Item ID/ MS27039-1-08

Replacement Mfg/

Purchased

**Primary** No

Last

Route 230

Unit of Each

Qty on Remaining 2,482.000 2.0000

Qty

Date

Status

Screw

Warehouse Loc Qty Loc Code Location Main Warehouse ST2482 3 110467 110552 479

110835

2000 230 Each

52.0000 1.0000

MS27039-4-06

Screw

Warehouse Loc Qty Loc Code Location Main Warehouse

230

ST

109061

52 52 Each

482.0000 60.0000

bl 10-03-1

**SCREW** 

MS27039C1-08

Loc Otv Loc Code Warehouse Location Main Warehouse ST 482

> 19185 482

60 bl 10-3-1

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W/O:			WORK ORDER CHANGES								
DATE	STEP	PRO	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
					l.						
Part No	:	PAR #:	Fault Cate	gory:	_ NCR	: Yes	No <b>DQ</b>	A:	_ Date: _		
Resolution:			Disposition: Q			QA: N/C Closed: Dat					
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR	)				
DATE	STEP	Description of NC	Corrective Action Section B			Verificat			Approval	Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector	
						<del>, , , , , , , , , , , , , , , , , , , </del>		- 1			
					- 1					<b>]</b> .	

QTY QTY QTY QTY **PART NUMBER** DESCRIPTION D2650-1 SKIDTUBE ASSEMBLY Х D2650-3 SKIDTUBE ASSEMBLY Х D2650-5 SKIDTUBE ASSEMBLY Х D2650-7 SKIDTUBE ASSEMBLY Х 1 D2600-1-160 **EXTRUSION** D2654-1 WE8 D2654-3 WEB 1 WEB D2654-5 1 D2654-7 WEB AFT CAP D2646 D2647 CAP 1 1 CROSS BOLT SPACER 19 23 D2649 17 18 16 18 14 22 D2651-1 PLUG 22 16 18 14 D2651-3 O-RING 1 1 D2680-041 **NUT PLATE** 2 2 D3286-1 DOUBLER D3286-3 2 2 STUD INSERT (or AKS4-1032-130, ALS4-1032-130, 54 60 ALS7-1032-130 42 44 ALS7-1032-130) WASHER 2 2 2 2 AN960JD10L CCR264SS3-3 RIVET 2 2 2 2 RIVET 2 2 2 CR3212-4-03 2 SCREW 2 2 2 2 MS27039-1-08 SCREW 1 MS27039-4-06 1 WASHER 1 AN960JD416 1 1 RIVET 52 52 CR3212-4-04 /F) NOTES: 1) MATERIAL: N/A

SHOP COPY **RETURN TO ENGINEEPING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 55775 BS 10-2-01



В

DRAWING UPDATED TO CURRENT STANDARDS, SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERED TO SHT 6, SHT 1 IN PL PART D2649 QTY AJS 80.80.80 UPDATED, SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239). 06.03.30 RMOVE CBORE, CHG DRILL, ADD CHAMFER CP REDRAW; INCORP. DE09136/9153/9163 CP 04.05.17 MOD GROUND HANDLING ON D2650-1/-3 С CHANGE HOLE PATTERN AND FRONT END DŞ 97,10.29 В AS MANUFACTURED CHANGES DS 97.06.26 NEW ISSUE DS Α 97.03.25

DESIGN DS DART AEROSPACE USA, INC DRAWN AJS PORT HADLOCK, WA CHECKED DRAWING NO. REV. F MFG. APPR. D2650 SHEET 1 OF 6 APPROVED TITLE SCALE 206/407 SKIDTUBE ASSEMBLIES NTS DE APPR. COPYRIGHT © 1997 BY DART AEROSPACE USA, INC DATE 08.08.08

D

С

В

Α

2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER

**DART QSI 005 4.4** 

3) TOLERANCES, PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: N/A

8) WELD PER DART QSI 004

9) DAMAGE TOLERANCE ON FWD BEND:

THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015

11) INSERT D2651-1 PLUG CW D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.

13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

REV.

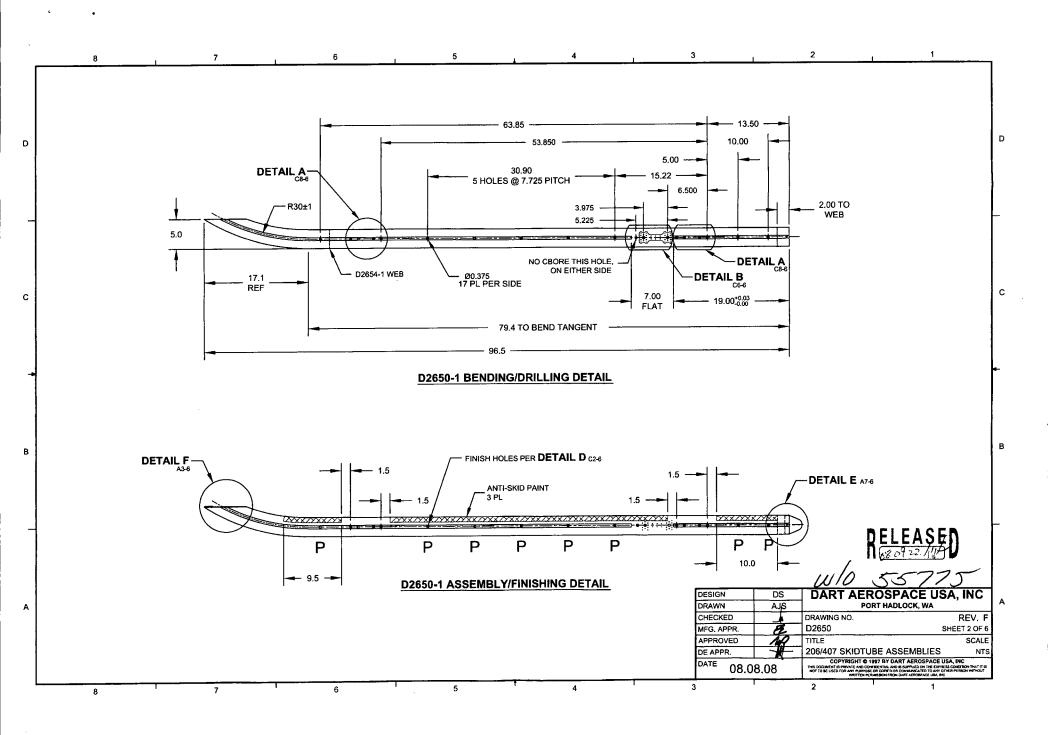
DESCRIPTION

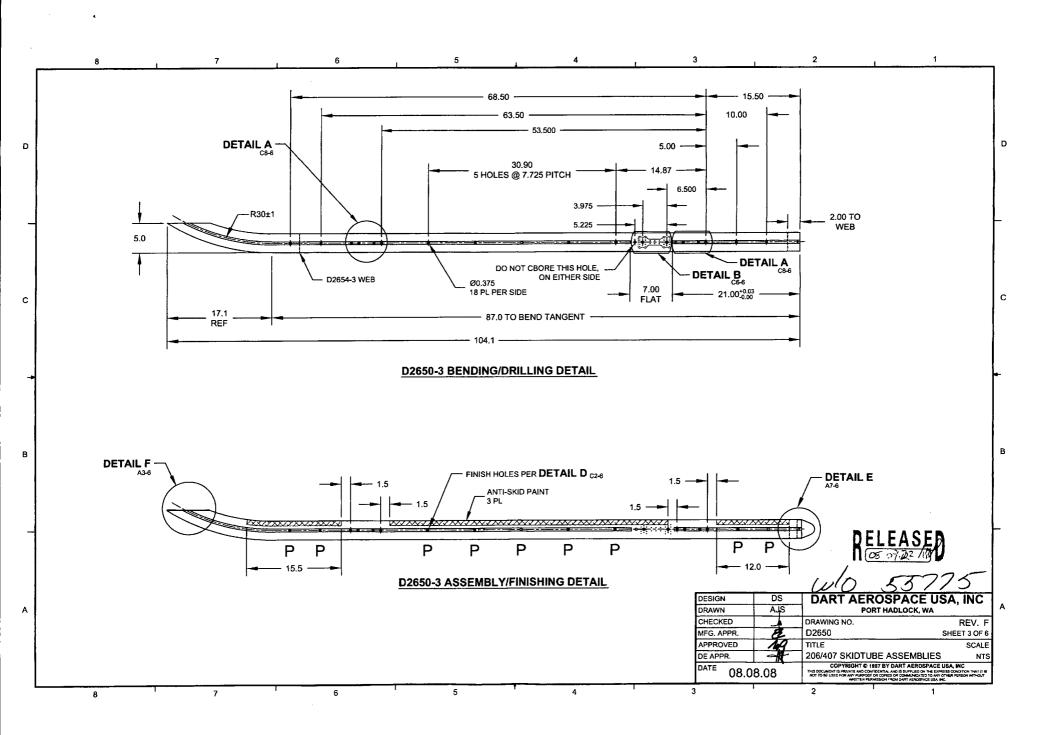
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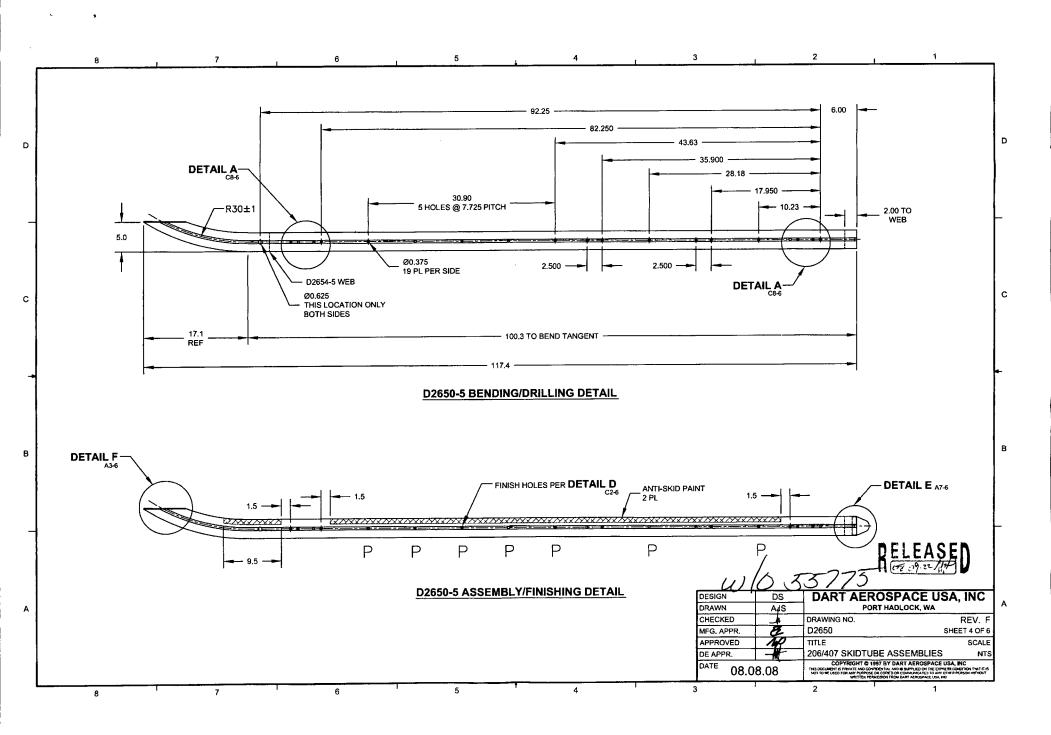
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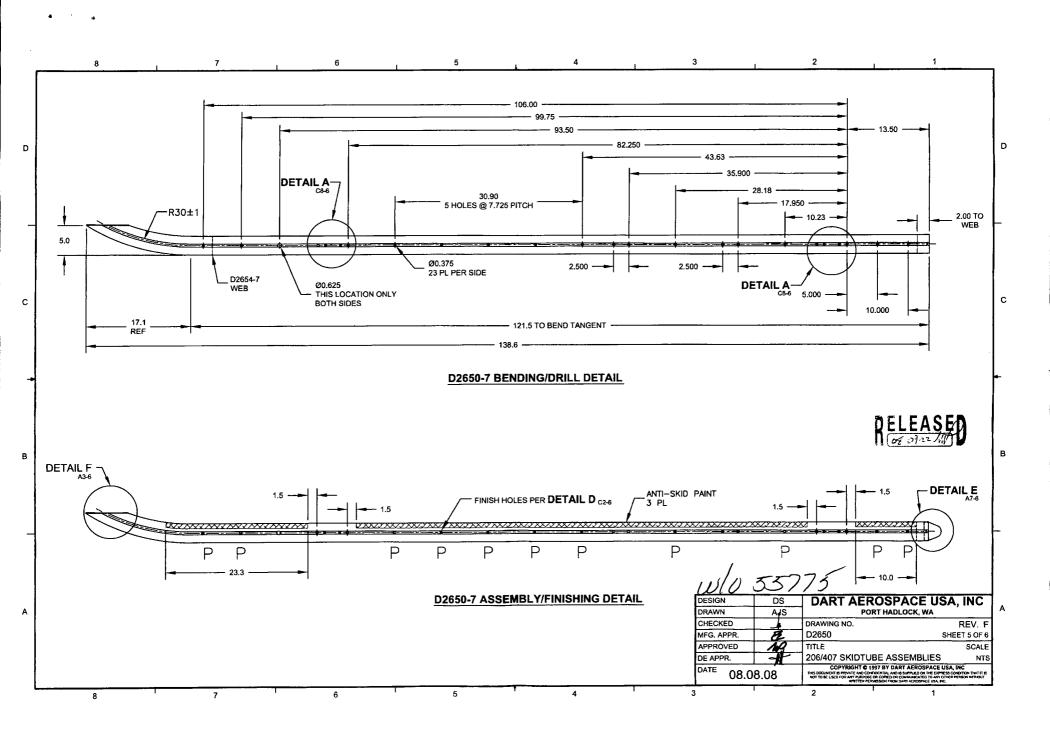
DATE

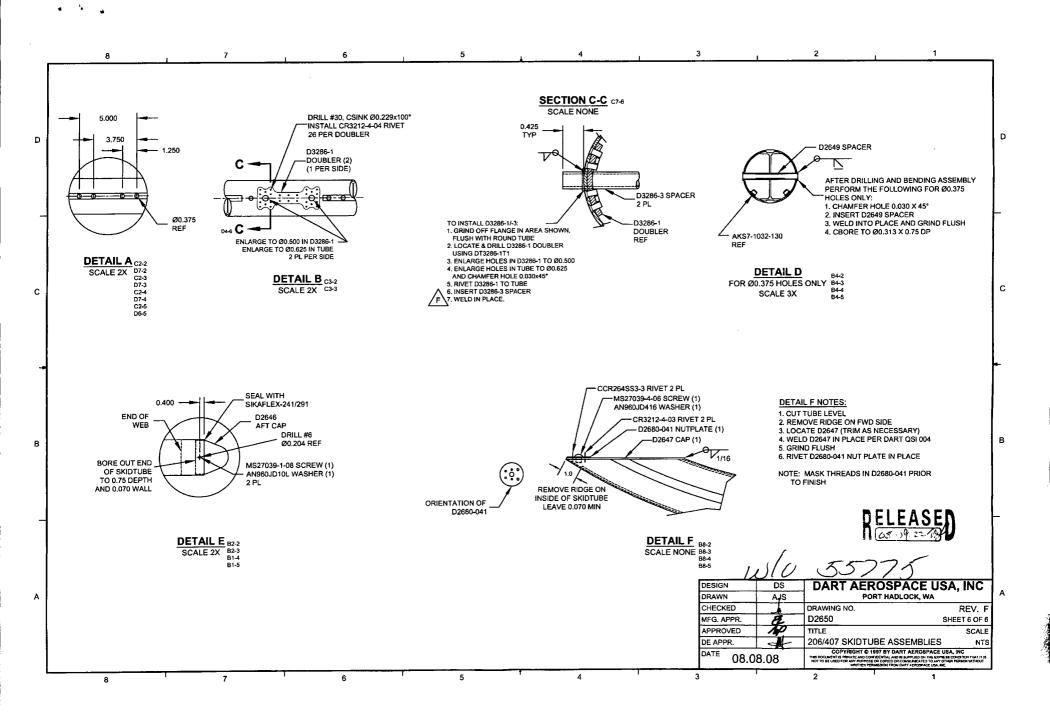
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NO. 323

# AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Darday Elliott	
Job number: 3 \$ 55777	
Part number: 0200-642-441	
Description: 200 skid to be	
Welding Process: Tig[ Mig[ ]	
Base materiel: Aluminian	
Current: AC[ DC[ ]	

# TEST REQUIREMENTS AND RESULTS

Visual: Penetration:	$pass[\sqrt{]}  fail[]$ $pass[\sqrt{]}  fail[]$	
<u>UNACCEPTABLE</u>		
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[ ] fail[ ]	
Qualifier Saf Saf Welder Dorcha Elliet	Date of Test Coupon 10.02.16  Date of Test Coupon 10-02-16	_

The above named individual is qualified in accordance with AWS D17.1.2001 to weld